

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014720**Date Inspected:** 15-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Bay 1: CB15.

This QA Inspector observed that no significant work was being performed on the above mentioned CB at the time when this QA was present.

Bay 8: CB17.

This QA Inspector observed that no significant work was being performed on the above mentioned CB at the time when this QA was present.

Trial Assembly:

CB9:

This QA Inspector observed the following work in progress:

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Shielded Metal Arc Welding (SMAW) of weld joints CB202A-009-007, 009, 010 & 012. Welders are identified as 067609 & 066171. ZPMC QC is identified as Li Jia. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4b-FCM-1 & WPS-2211-TC-U4b-FCM-1. These joints, as per drawing, are to be fillet welded. However, these are welded as CJP welds. ZPMC QC agreed that they will do Magnetic particle testing (MT) and Ultrasonic testing (UT) of these welds and CT QA will also be notified for the same.

CB10:

This QA Inspector observed that no significant work was being performed on the above mentioned CB at the time when this QA was present.

Outside Yard:

CB11, CB12, CB13, CB14 & CB16:

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

Notification No: 005986:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components – SEG 7BW & SEG 7DW. The weld designations reviewed are as follows:

For OBG SEG 7BW:

- FB027-PP52- 128, 013 to 018.
- FB023-PP51- 128, 013 to 018.
- FB039-PP50- 128, 013 to 018.
- SEG035D- 045, 046, 068, 069, 131, 132, 158 & 159.
- BP025-CB7- 030, 031, 042 & 043.

For OBG SEG 7DW:

- FB023-PP57- 128, 011 to 016.
- FB019-PP56- 128, 011 to 016.
- FB027-PP58- 128, 011 to 016.
- BP025-CB8- 034 to 037, 040 to 041, 028 & 029.
- SEG-039D- 131, 132, 140, 141, 068, 069, 158 & 159.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Hall,Steven
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QA Reviewer
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